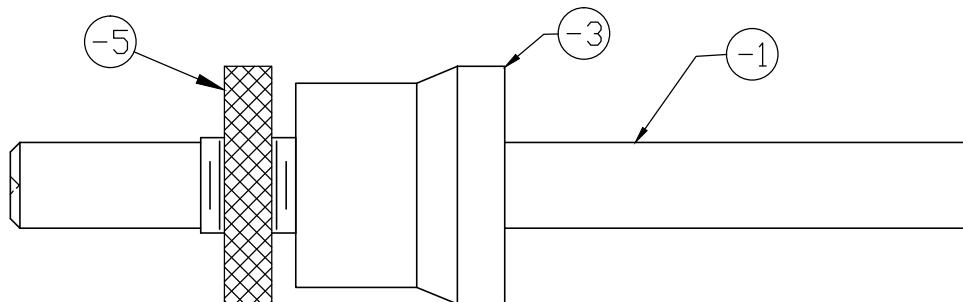


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REV		DESCRIPTION	DATE	INITIAL	APPROVED
1		SURFACE FINISH ADDED TWO PLACES, $\phi$ TOLERANCE ADDED TWO PLACES.	3/17/03		
2		ADDED NOTES & DIA. CHANGE REFER TO MASTER, DELETED ROLL PIN HOLE.	9/9/05		
3		CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, ADDED ENGRAVE NOTE -5 & -3, CH'D -1 DIA. FROM .92 TO .930 & -3 DIA. FROM 2.175 TO 2.150 PER G.E.	1/8/09	RJC	RW



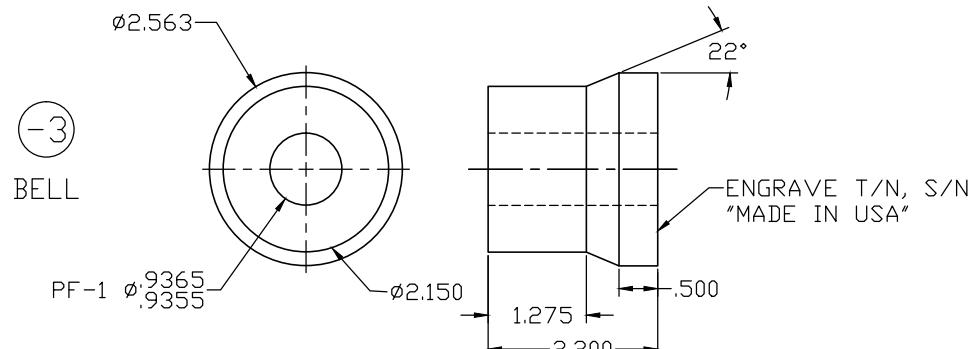
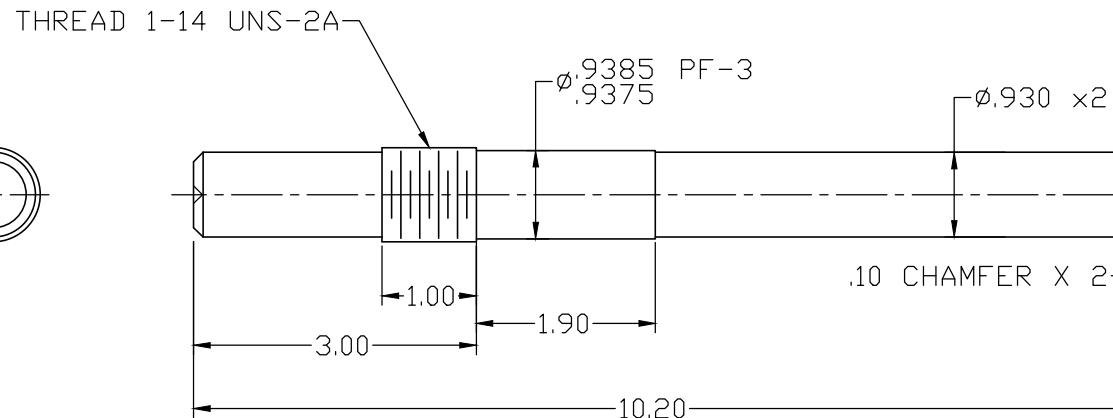
ASSEMBLY

ASSY	ASSY	B/D	PART #	QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	$\phi 1-1/16 \times 10-1/4$	2
	1		-3		BELL	STRESS PROOF	$\phi 2-9/16 \times 2-1/4$	2
			-5	1	KNURLED NUT	STRESS PROOF	$\phi 2-1/2 \times 1/2$	3
		X	-7	1	MACHINED ASSEMBLY			4
ASSY	-7							

RB RED BARN MACHINE	
TITLE M/R TRUNION CENTERING TOOL	
DWG NO.	RBT18530B
REV	3
UNLESS OTHERWISE SPECIFIED	DRAWN BY: COLE
DIMENSIONS ARE IN INCHES	APPROVED
TOLERANCES ON:	HEAT
DECIMALS	TREAT
XXX $\pm .005$	FINISH
XX $\pm .01$	SPEC
X $\pm .1$	USED ON MODEL
	BELL 206B3
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 4-8-04
	SHEET 1 of 4

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REV		DESCRIPTION	DATE	INITIAL	APPROVED
1		SURFACE FINISH ADDED TWO PLACES, $\phi$ TOLERANCE ADDED TWO PLACES.	3/17/03		
2		ADDED NOTES & DIA. CHANGE REFER TO MASTER, DELETED ROLL PIN HOLE.	9/9/05		
3		CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL ADDED ENGRAVE NOTE -5 & -3, CH'D -1 DIA. FROM .92 TO .930 & -3 DIA. FROM 2.175 TO 2.150 PER G.E.	1/8/09	RJC	RW



NOTE:  
LEAVE ALL OD'S OVERSIZED AND CUT TO FINISH  
DIMENSIONS AFTER ASSEMBLY -1 & -3.

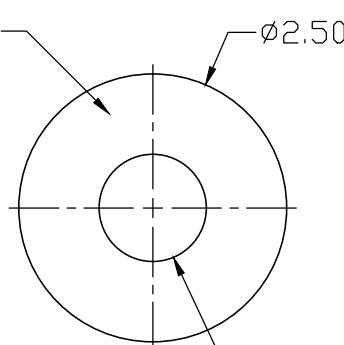
RED BARN MACHINE		
TITLE M/R TRUNION CENTERING TOOL		
DWG NO. RBT18530B-1 & -3 REV 3		
UNLESS OTHERWISE SPECIFIED DRAWN BY COLE		
DIMENSIONS ARE IN INCHES APPROVED		
TOLERANCES ON DECIMALS HEAT TREAT		
XXX $\pm .005$ FRACTIONS $\pm 1/32$ FINISH SPEC SEE ASSEMBLY		
XX $\pm .01$ ANGLES $\pm 5^\circ$		
X $\pm .1$		
UNLESS OTHERWISE SPECIFIED USED ON MODEL		
1. BREAK ALL SHARP EDGES BELL 206B3		
.015 x 45° PR .015 R		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE NTS	DATE 4-8-04	SHEET 2 of 4

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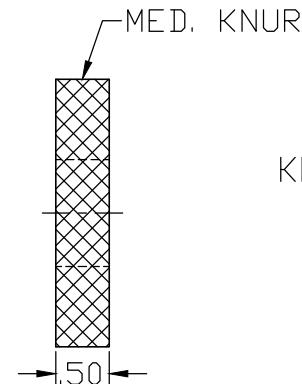
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
3	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, ADDED ENGRAVE NOTE -5 & -3, CH'D -1 DIA. FROM .92 TO .930 & -3 DIA. FROM 2.175 TO 2.150 PER G.E.	1/8/09	RJC RW

ENGRAVE T/N/, S/N,  
"MADE IN USA"

TO FIT



DRILL & TAP  
1-14 UNS-2B THRU

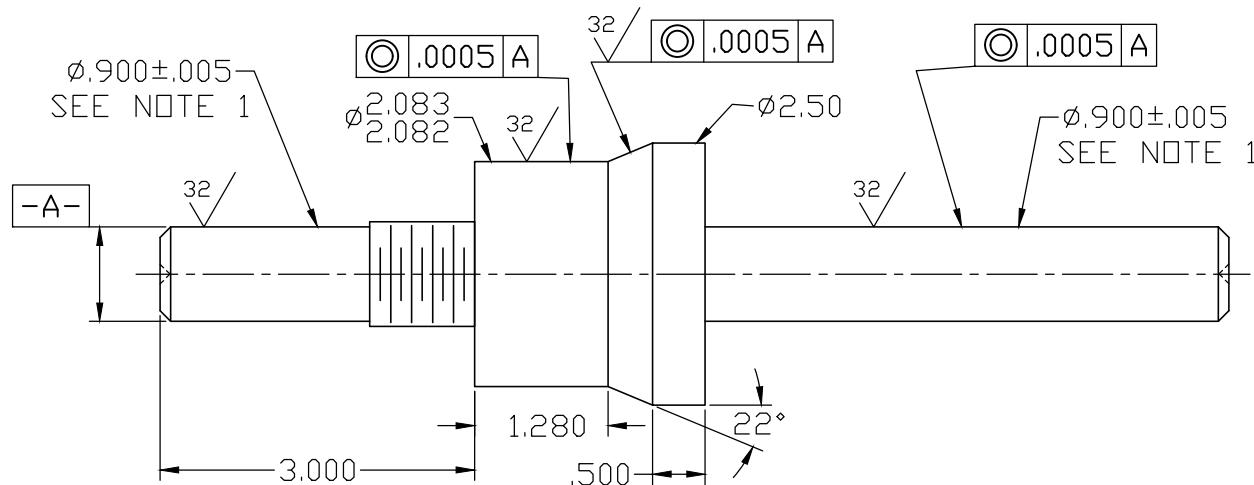


MED. KNUURL  
(-5)  
KNURLED  
NUT

RB RED BARN MACHINE	
TITLE M/R TRUNION CENTERING TOOL	
DWG NO.	RBT18530B-5
REV	3
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON	
DECIMALS	
XXX $\pm$ .005	FRACTIONS $\pm$ 1/32
XX $\pm$ .01	ANGLES $\pm$ .5°
X $\pm$ .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY:	COLE
APPROVED	
HEAT	
TREAT	
FINISH	
SPEC	BLACK OXIDE
USED ON MODEL	
BELL 206B3	
SCALE	NTS
DATE	4-8-04
SHEET	3 of 4

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REV		DESCRIPTION		DATE	INITIAL	APPROVED
1		SURFACE FINISH ADDED TWO PLACES, $\phi$ TOLERANCE ADDED TWO PLACES.		3/17/03		



(-7)

MACHINED ASSEMBLY  
FINISH DIMENSIONS

NOTES

1. TOLERANCE .002 BETWEEN FRONT SHAFT DIA. & BACK SHAFT DIA.

RED BARN MACHINE		
TITLE M/R TRUNION CENTERING TOOL		
DWG NO. RBT18530B REV 3		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX $\pm .005$ FRACTIONS $\pm 1/32$ XX $\pm .01$ ANGLES $\pm 5^\circ$ X $\pm 1$		
DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC: BLACK OXIDE USED ON MODEL: BELL 206B3		
UNLESS OTHERWISE SPECIFIED		
1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SCALE NTS	DATE 4-8-04	SHEET 4 of 4